



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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S202043

D350-591-214

Job Sheet 196465-A



Part No: D350-591-214

Job Qty: 1 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Due Date: 7/29/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:E 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Packaging 1 - Pick Kit	1 pcs	7/29/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		



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Container No: S202043



Part: D350-591-214

Job No: 196465-A

Serial No/Batch: S201519

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 16 FAA STC SH967NE

				Packaging 1 - 30	
				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
270 Packaging 1-1 - Pick Kit - B4B 1 pcs	7/29/19	0.00 0.00	Packaging 1 - 1 - B4B		
			Packaging 1 - 2 - B4B		
			Packaging 1 - 3 - B4B		
			Packaging 1 - 4 - B4B		
			Packaging 1 - 5 - B4B		
			Packaging 1 - 6 - B4B		
			Packaging 1 - 7 - B4B		
			Packaging 1 - 8 - B4B		
			Packaging 1 - 9 - B4B		
			Packaging 1 - 10 - B4B		
			Packaging 1 - 11 - B4B		
			Packaging 1 - 12 - B4B		
			Packaging 1 - 13 - B4B		
			Packaging 1 - 14 - B4B		
			Packaging 1 - 15 - B4B		
			Packaging 1 - 16 - B4B		
			Packaging 1 - 17 - B4B		
			Packaging 1 - 18 - B4B		
			Packaging 1 - 19 - B4B		
			Packaging 1 - 20 - B4B		
			Packaging 1 - 21 - B4B		
			Packaging 1 - 22 - B4B		
			Packaging 1 - 23 - B4B		
			Packaging 1 - 24 - B4B		
			Packaging 1 - 25 - B4B		
			Packaging 1 - 26 - B4B		
			Packaging 1 - 27 - B4B		
			Packaging 1 - 28 - B4B		
			Packaging 1 - 29 - B4B		
			Packaging 1 - 30 - B4B		
			Packaging 1 - 31 - B4B		
			Packaging 1 - 32 - B4B		
			Packaging 1 - 33 - B4B		
			Packaging 1 - 34 - B4B		
			Packaging 1 - 35 - B4B		
			Packaging 1 - 36 - B4B		
280 QC 4 1 pcs	7/29/19	0.00 0.00	QC 4 - 28		
			QC 4 - 58		
			QC 4 - 69		
			QC 4 - 9		
			QC 4 - 46		
			QC 4 - 68		
			QC 4 - 72		
			QC 4 - 74		
290 Packaging 3-1 - Stock - B4B 1 pcs	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B		
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		

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				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
295	DC - 1 - B4B	1 pcs	7/29/19	0.00 0.00	DC - 1 - B4B	DAS 21 9-89
					DC - 2 - B4B	
300	QC 21 - FG	1 pcs	7/29/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op **280** - (QC4- 100% Inspect kits for completeness)
 Descriptions: **290** - Identify and pack for shipping as per PPP D350-591-214 Location:FG039
295 - Photocopy bluefile and type labels as per PPP D350-591-214 CHG005
300 - QC21- Final Inspection - Work Order Release

Job BOM

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Packaging 1 - Pick Kit	AN3-35A	2	350	0
	AN4-15A	4	412	0
	AN4-16A	4	1,031	0
	AN5-36A	2	245	0
	D2230-3	2	740	0
	D2618	2	192	0
	D2732-030	4	448	0
	D3235-1	2	313	0
	D3338-1	1	108	0
	MS21042L3	2	826	0
	MS21042L4	6	2,581	0
	MS21042L5	2	413	0
	NAS1149D0363J	4	1,754	0
	NAS1149D0463J	12	4,772	0
	NAS1149D0563J	4	2,089	0
270-Packaging 1-1 - Pick Kit - B4B	D3078-042	1	24	0
Part Specifications				
Specifications could not be found.				

Plex 7/31/19 2:30 PM dart.lacelle.linda



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D350-591-214
Job Sheet 196465



Part No: D350-591-214

Job Qty: 4 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/13/19

Job Tracking No:

Due Date: 7/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.11.15 update qty on AN4-11A DD ver:EC IPP REV:E 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Packaging 1 - Pick Kit	4 pcs		7/29/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23	PC	JUL 29 2019
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		

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Container No: S201519



Part: D350-591-214

Job No: 196465

Serial No/Batch: S201519

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 14 of 14 STC SH967NF

					Packaging 3 - 9 - B4B						
					Packaging 3 - 10 - B4B						
					Packaging 3 - 11 - B4B						
					Packaging 3 - 12 - B4B						
					Packaging 3 - 13 - B4B						
					Packaging 3 - 14 - B4B						
					Packaging 3 - 15 - B4B						
					Packaging 3 - 16 - B4B						
					Packaging 3 - 17 - B4B						
					Packaging 3 - 18 - B4B						
					Packaging 3 - 19 - B4B						
					Packaging 3 - 20 - B4B						
					Packaging 3 - 21 - B4B						
					Packaging 3 - 22 - B4B						
					Packaging 3 - 23 - B4B						
					Packaging 3 - 24 - B4B						
					Packaging 3 - 25 - B4B						
					Packaging 3 - 26 - B4B						
					Packaging 3 - 27 - B4B						
					Packaging 3 - 28 - B4B						
					Packaging 3 - 29 - B4B						
					Packaging 3 - 30 - B4B						
					Packaging 3 - 31 - B4B						
					Packaging 3 - 32 - B4B						
					Packaging 3 - 33 - B4B						
					Packaging 3 - 34 - B4B						
					Packaging 3 - 35 - B4B						
					Packaging 3 - 36 - B4B						
					295 DC - 1 - B4B	4 pcs	7/29/19	0.00	0.00	DC - 1 - B4B	
					300 QC 21 - FG	4 pcs	7/29/19	0.00	0.00	DC - 2 - B4B	
										QC 21 - FG - 21	
										QC 21 - FG - 70	
										QC 21 - FG - 53	

Part Op 280 - (QC4- 100% inspect kits for completeness)

Descriptions: 290 - Identify and pack for shipping as per PPP D350-591-214 Location:FG039

295 - Photocopy bluefile and type labels as per PPP D350-591-214 CHG005

300 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	8 Ea (2 ea)	90-Packaging 1 - Pick Kit	5158554
AN4-15A	Bolt	16 Ea (4 ea)	90-Packaging 1 - Pick Kit	5173406
AN5-36A	Bolt	8 Ea (2 ea)	90-Packaging 1 - Pick Kit	5158937
D2230-3	Mounting Lug	8 pcs (2 ea)	90-Packaging 1 - Pick Kit	5176023
D2230-3	Bushing	8 pcs (2 ea)	90-Packaging 1 - Pick Kit	5171371
D2732-030	Rubber Cushion - 3"	16 pcs (4 ea)	90-Packaging 1 - Pick Kit	5198520
D3235-1	Mounting Lug	5 pcs (2 ea)	90-Packaging 1 - Pick Kit	5150055
D3338-1	Mounting Lug	4 pcs (1 ea)	90-Packaging 1 - Pick Kit	5196020
MS21042L3	Nut	8 Ea (2 ea)	90-Packaging 1 - Pick Kit	5149299
MS21042L4	Nut	24 Ea (6 ea)	90-Packaging 1 - Pick Kit	5178112
MS21042L5	Nut	8 Ea (2 ea)	90-Packaging 1 - Pick Kit	5166979
NAS1149D0383J	Washer	16 Ea (4 ea)	90-Packaging 1 - Pick Kit	5146545
NAS1149D0463J	Washer	48 Ea (12 ea)	90-Packaging 1 - Pick Kit	5178113
NAS1149D0563J	Washer	16 Ea (4 ea)	90-Packaging 1 - Pick Kit	5174288
AN4-16A	Bolt	16 Ea (4 ea)	90-Packaging 1 - Pick Kit	5170118
D3078-042	Step Assembly, Hi Short RH	4 pcs (1 ea)	270-Packaging 1-1 - Pick Kit - B4B	5163271

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Packaging 1 - Pick Kit	AN3-35A	8	402	0
	AN4-15A	16	256	0
	AN4-16A	16	503	0
	AN5-36A	8	130	0
	D2230-3	8	393	0
	D2618	8	114	0
	D2732-030	16	402	0
	D3235-1	8	365	0
	D3338-1	4	126	0
	MS21042L3	8	1,635	0
	MS21042L4	24	1,812	0
	MS21042L5	8	609	0
	NAS1149D0363J	16	1,203	0
	NAS1149D0463J	48	2,872	0
	NAS1149D0563J	16	2,624	0
	D3078-042	4	4	0
270-Packaging 1-1 - Pick Kit - B4B				
Part Specifications				
Specifications could not be found.				

Plex 6/13/19 11:27 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining Large Fab ☐ Cross tube Small Fab Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging ☐ Engineering Water Jet Supplier Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Completed By		Lead hand / Supervisor			
		QC / QA Coordinator			

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step - High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step - High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step - Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step - Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step - High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step - High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
						D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.